Work Order ID 70393

Tuesday, June 07, 2011 7:34:41 AM

Item ID: D117-762-041 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Replacement Skidtube

Start Date: 6/7/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 6/17/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** CSL **Date:** 11/06/07 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D3492	C
D3582	Rev A

100 0.00

DC

Document Control

DOCUMENT CONTROL

Memo 0.00

Photocopy bluefile & type labels per PPP D117-762-041 CHG001

HA CK 11/06/07

120 0.00

CNC Bend 1

CNC Delta 100 Bender

BENDING MACHINE - SKIDTUBES

Memo 0.00

Bend tube as per program D3582 on CNC Bender and Dwg D3582. Folio 3, use bending aid DT9632

2- cut fwd end of tube as per dwg

11-6-7

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Skidtubes	0.00							
Skidtubes		0.00							
Skidtubes	**Memo**								

1-Cut Aft end using DT8185

2-Deburr ends

3-Drill Aft Cap holes using DT8678 ***DO NOT OPEN AFT CAP HOLE***

4-Locate DT 8973 & Drill Ground wire hole on top of Tube.

5-Install 3/16 cleco in Ground wire hole ,then drill all X-Bolt holes using 3/16" drill.

6-Drill pilot holes for wearplates using DT8974

7-Open wearplate holes to Ø19/64" (0.297") as per Dwg D3582.

8- open ground wear holes to 0.391" as per section B-B

9-Open Aft Cap holes using .209" drill.

10-Drill pilot holes for section D-D and E-E. Holes must be laid out by hand. Mark out Center line and make sure that 6.65 and 5.906 measurements are respected. Double check before drilling, do not open holes to finish size.

11-6-7

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W/O:		WORK ORDER CHANGES					
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Skidtubes	0.00							
Skidtubes	**Memo**	0.00							
Skidtubes	1-Weld fwd cap D2964 per dwg D3582 and QSI 004 A/R AL ROD Batch: M112660/M117456 BE 11/06/07 2-Grind flush DP 11-6-7								
150	QC10- Inspect visual per QSI004- ground welds	0.00							
QC	**Memo**	0.00							
Quality Control									
160	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control									

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	**Memo**	0.00							
Hand Finishing									
180	QC3- Inspect Part Finish	0.00							
QC	**Memo**	0.00							
Quality Control									

11-6-7

1 Ø BE 11/06/07

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W/O:		WORK ORDER CHANGES					
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Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Skidtubes	0.00							
Skidtubes	**Memo**	0.00							
Skidtubes	1-Open X-Bolt holes to finish size as per Dwg D3582, all sections								
	2-Counter Sink X-BOLT holes as per Dwg D3582								
	3-Deburr and blow out chips from inside of tube, prep. tube for welding.								
	4-Bond web as per Dwg D3582 & QSI 015 A/R 241 Sike Flex Batch: M116945 Exp Date: 12/01/15.								
	5-Weld x-bolt spacers(D2973) as per Dwg D3582 section B-B. A/R AL ROD Batch: M112660								
	6-Grind welds flush								
200	QC10- Inspect visual per QSI004- ground welds	0.00							
QC	**Memo**	0.00							
Quality Control									

11-6-7

DL 11/06/07

BE 11/06/08

BB 11/06/09

5 wlo6/09

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W/O:		WORK ORDER CHANGES					
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Run Start
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00							
215 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 **Memo** Touch-up alodine as per QSI	0.00 0.00							
220 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum **Memo** START TIME 12:50 OVEN TEMPERATURE: 320°F FINISH TIME: 1:20	0.00 0.00							

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W/O:		WORK ORDER CHANGES					
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Work Order ID 70393

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Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	QC3- Inspect Part Finish	0.00				1	BL	11-6-9	
QC	**Memo**	0.00							
Quality Control									
240		0.00							
HandFinish	HandFinishing					1	BL	11-6-9.	
Hand Finishing	**Memo**	0.00							
	Install Wearplate &Ground Wire inserts as per Dwg D3582.								

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Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	HandFinishing	0.00							
HandFinish	**Memo**	0.00							
Hand Finishing	1-Inspect for Foreign objects								
	2-Install Aft cap as per Dwg D3582, Detail "C" A/R 241 Sika Flex Batch: 116945 Exp Date: 12-01								
	3-Install Wearplates as per Dwg D3582 , Note:Install Bolt and washer on Ground Wire inserts on top of tube see section D-D of dwg D3582 *******Do not install bolts where indicated on Dwg(Note #6)****** A/R 241 Sika Flex Batch: 116945 Exp Date: 12-01								
	4-assemble o'ring as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: 114189								
	5- Wing Walk as per Dwg D3582 and QSI 005 4.4 117315								
260	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control									

BK 11-6-9

BK 6 w/oe 07

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W/O:		WORK ORDER CHANGES					
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Run Start
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	Packaging	0.00							
Packaging									
Packaging	**Memo**	0.00							
	Identify and pack for shipping as per PPP D117-762-041 Location:_____ PPP Rev:_____								
280	QC21- Final Inspection - Work Order Release	0.00							
QC									
Quality Control	**Memo**	0.00							

PPP 70402

ok 11/06/09

11-06-1

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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Picklist Print

Tuesday, June 07, 2011 7:34:37 AM

Work Order ID: 70393

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube

Start Date: 6/7/2011 **Required Date:** 6/17/2011

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP Rev:A☐07.06.11☐New Issue☐ EC
IPP Rev:B 08-02-22 change to revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3492-11 Plug		Manufactured	No		70410	250	Each	0.0000	2	2	2 BR 11-6-9		
D3492-13 Plug		Manufactured	No			250	Each	45.0000	6	6			
				Location				**Loc Qty**		**Loc Code**			
				FP-B				45			6 BR 11-6-9		
					46693			45					
D3492-9 Plug		Manufactured	No			250	Each	51.0000	2	2			
				Location				**Loc Qty**		**Loc Code**			
				FP-A				51			2 BR 11-6-9		
					46694			51					
D2962-150 3.540 Outer Tube, Extrut		Manufactured	No				Each	85.0000		1			
				Location				**Loc Qty**		**Loc Code**			
				HALL				85			1 11-6-7		
					28672			12					
					59934			73					

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Tuesday, June 07, 2011 7:34:37 AM

Work Order ID: 70393

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube

Start Date: 6/7/2011 **Required Date:** 6/17/2011

Start Qty: 1.00 **Required Qty:** 1.00

D2964	Manufactured	No	140	Each	25.0000	1	1	BE 11/06/07
Cap								

Location	Loc Qty	Loc Code
LG002	25	
14101	10	
64654	15	

D2971	Manufactured	No	190	Each	20.0000	1	1	BE 11/06/08
Cross Bolt Spacer								

Location	Loc Qty	Loc Code
LG001	20	
44445	20	

D3584-1	Manufactured	No	190	Each	0.0000	1	1 x1	DL 11/06/07
Web								

B 70391

D2973	Manufactured	No	190	Each	145.0000	2	2	BE 11/06/08
Cross Bolt Spacer								

Location	Loc Qty	Loc Code
LG002	145	
14636	145	

D3662-3	Manufactured	No	190	Each	20.0000	1	1	BE 11/06/08
Crossbolt Spacer								

Location	Loc Qty	Loc Code
LG001	20	
44456	20	

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Work Order ID: 70393

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Parent Item Name: Replacement Skidtube

Start Date: 6/7/2011 **Required Date:** 6/17/2011

Start Qty: 1.00 **Required Qty:** 1.00

D3662-1	Manufactured	No		190	Each	16.0000	3	3

Crossbolt Spacer

Location		Loc Qty	Loc Code
LG001		16	
	64451	16	

ALS4-1032-130	Purchased	No		240	Each	1,920.000	36	36

Insert

Location		Loc Qty	Loc Code
ST281		8	
	117331	8	
ST282		1912	
	117717 ✓	1912	

ALS4-428-165	Purchased	No		240	Each	535.0000	2	2

Inserts

Location		Loc Qty	Loc Code
FP		490	
	117769	490	
FP-B		45	
	114172 ✓	45	

D2965	Manufactured	No		250	Each	31.0000	1	1

Cap, 105 Skidtube

Location		Loc Qty	Loc Code
FP006		31	
	52057 ✓	31	

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Work Order ID: 70393

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube

Start Date: 6/7/2011 **Required Date:** 6/17/2011

Start Qty: 1.00 **Required Qty:** 1.00

D3508-3	Manufactured	No		250	Each	9.0000	1	1

Wearplate

Location	Loc Qty	Loc Code
FP021	9	
38527	1	
65192	1	
67489 ✓	7	

D3508-9	Manufactured	No		250	Each	2.0000	1	1

Wearplate

Location	Loc Qty	Loc Code
FP021	2	
65193 ✓	2	

D3558-3	Manufactured	No		250	Each	12.0000	1	1

Gasket

Location	Loc Qty	Loc Code
FP014	12	
67486 ✓	12	

D3558-9	Manufactured	No		250	Each	9.0000	1	1

Gasket

Location	Loc Qty	Loc Code
FP014	9	
55469 ✓	9	

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Picklist Print

Tuesday, June 07, 2011 7:34:38 AM

Work Order ID: 70393

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube

Start Date: 6/7/2011 **Required Date:** 6/17/2011

Start Qty: 1.00 **Required Qty:** 1.00

D3558-11	Manufactured	No		250	Each	3.0000	1	1	
Gasket									
		Location		**Loc Qty**	**Loc Code**				
		FP014	62885	3					
				3					
D3558-13	Manufactured	No		250	Each	28.0000	1	1	
Gasket									
		Location		**Loc Qty**	**Loc Code**				
		FP014	59558	28					
				28					
D3508-11	Manufactured	No		250	Each	12.0000	1	1	
Wearplate									
		Location		**Loc Qty**	**Loc Code**				
		FP016	69941	12					
				12					
D3508-13	Manufactured	No		250	Each	6.0000	1	1	
Wearplate									
		Location		**Loc Qty**	**Loc Code**				
		FP016	65191	6					
				6					
AN960JD10L NAS1149D0332J	Purchased	No		250	Each	0.0000	2	2	
Washer			117296						

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Tuesday, June 07, 2011 7:34:38 AM

Work Order ID: 70393

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube

Start Date: 6/7/2011 **Required Date:** 6/17/2011

Start Qty: 1.00 **Required Qty:** 1.00

AN3C4A	Purchased	No		250	Each	2,217.000	28	28

BOLT

Location		Loc Qty	Loc Code
ST350		2217	
	117094 ✓	715	
	117313	2	
	117688	800	
	117795	500	
	117872	200	

28 BK 11-6-9

AN3C5A	Purchased	No		250	Each	1,813.000	2	2

Bolt

Location		Loc Qty	Loc Code
FP-A		7	
	115835	7	
ST350		1806	
	116419 ✓	152	
	116549	54	
	117343	500	
	117508	300	
	117764	300	
	117872	500	

2 BK 11-6-9

AN960JD416L	NAS1149D0416J ✓	Purchased	No	250	Each	3.0000	2	2

Washer

Location		Loc Qty	Loc Code
FP-B		3	
	110153 ✓	3	

2 BK 11-6-9

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Tuesday, June 07, 2011 7:34:38 AM

Work Order ID: 70393

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube

Start Date: 6/7/2011 **Required Date:** 6/17/2011

Start Qty: 1.00 **Required Qty:** 1.00

AN960C10L	NAS1149C0332R	Purchased	No		250	Each	0.0000	28	28	
washer				117291.					28.	BL 11-6-9
AN4-4A		Purchased	No		250	Each	102.0000	2	2	
Bolt										

Location	Loc Qty	Loc Code		
FP-B	48			
114615	48		2	BL 11-6-9
ST356	54			
114615	54			

NAS1611-012		Purchased	No		250	Each	68.0000	6	6	
O-RING										

Loeation	Loc Qty	Loc Code		
FP-A	68			
113845	68		6.	BL 11-6-9

NAS1611-015		Purchased	No		250	Each	91.0000	2	2	
O-RING										

Location	Loc Qty	Loc Code		
FP-A	91			
115101	91		2	BL-11-6-9

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Tuesday, June 07, 2011 7:34:38 AM

Work Order ID: 70393

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube

Start Date: 6/7/2011 **Required Date:** 6/17/2011

Start Qty: 1.00 **Required Qty:** 1.00

NAS1611-016	Purchased	No		250	Each	109.0000	2	2

O-RING

Location	Loc Qty	Loc Code
FP-A	109	
107178	7	
112492	58	
113524	44	

2 BK 11-6-9.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

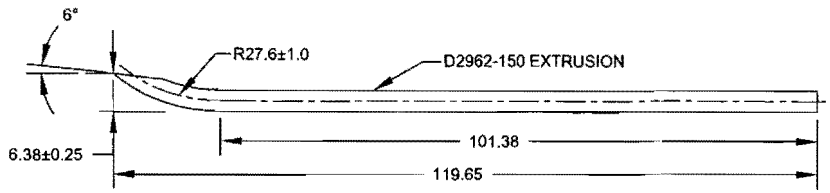
NOTE: Date & initial all entries

PARTS LIST FOR D3582-041 SKIDTUBE ASSEMBLY

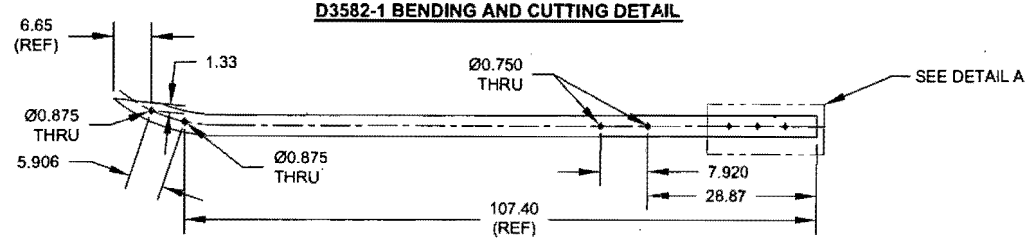
Qty	Part Number	Description
X	D3582-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2964	CAP
1	D2965	CAP
1	D2971	CROSS BOLT SPACER
2	D2973	CROSS BOLT SPACER
2	D3492-049	PLUG ASSEMBLY
2	D3492-051	PLUG ASSEMBLY
6	D3492-053	PLUG ASSEMBLY
1	D3508-3	WEARPLATE
1	D3508-9	WEARPLATE
1	D3508-11	WEARPLATE
1	D3508-13	WEARPLATE
1	D3558-3	GASKET
1	D3558-9	GASKET
1	D3558-11	GASKET
1	D3558-13	GASKET
1	D3584-1	WEB
3	D3662-1	CROSS BOLT SPACER
1	D3662-3	CROSS BOLT SPACER
36	AELS-1032-130	INSERT
2	ALS7-428-165	INSERT
28	AN3C4A	BOLT
2	AN3-5A	BOLT
2	AN4-4A	BOLT
28	AN960C10L	WASHER
2	AN960JD10L	WASHER
2	AN960JD416L	WASHER

GENERAL NOTES:

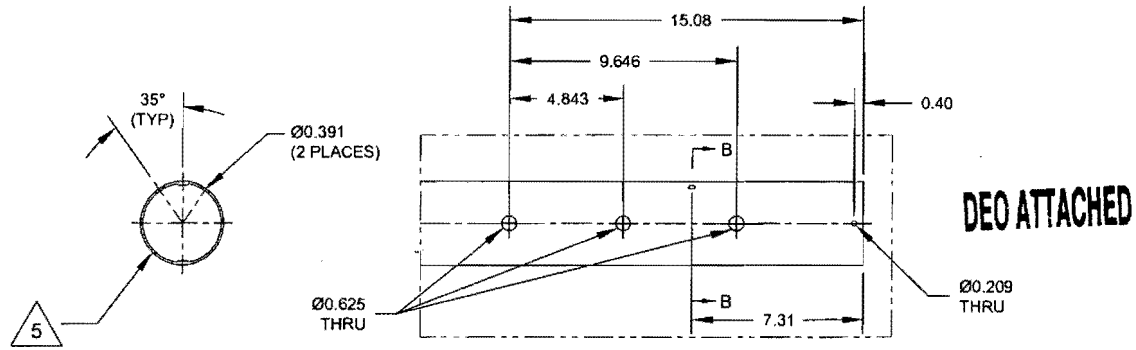
1) ALL DIMENSIONS ARE IN INCHES
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) WELDING TO BE DONE PER DART QSI 004.
4) INSERT D3584-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING.
5) USE DART DRILL TEMPLATE DT8900 TO LOCATE AND DRILL Ø0.297 HOLES (36 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION G-G (36 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
6) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS.
7) FINISH:
 A) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3584-1 WEB.
 B) POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3.
 C) ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4



D3582-1 BENDING AND CUTTING DETAIL



D3582-1 DRILLING DETAIL



SECTION B-B
SCALE 1:5

DETAIL A
SCALE 1:5

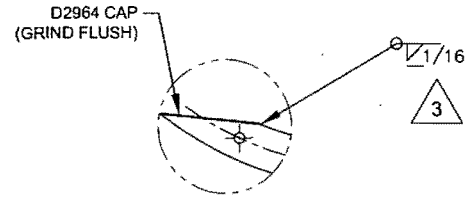
RELEASED
07.11.22 MD

CL 11/06/07
WO: 70393

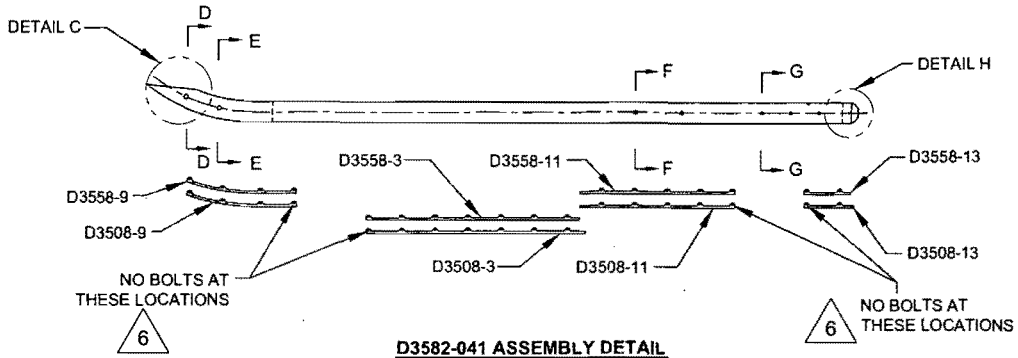
REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	PH	07.06.08

DESIGN		DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3582	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BK 117 SKIDTUBE ASSEMBLY	1:20
DATE	07.06.08		

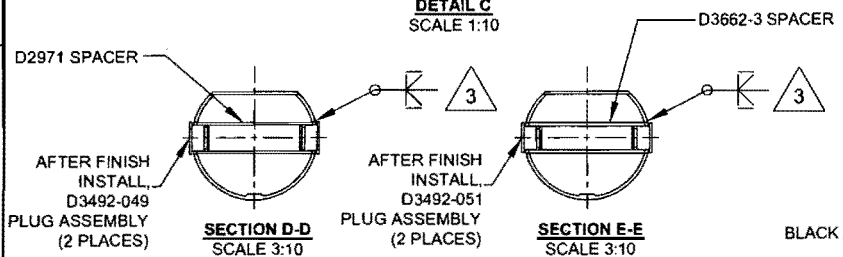
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DETAIL C
SCALE 1:10

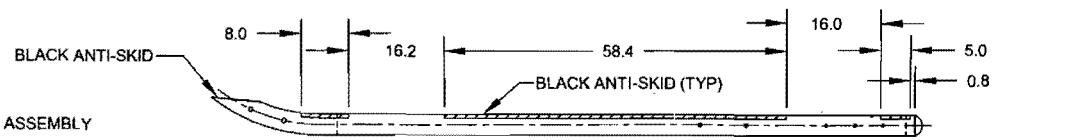


D3582-041 ASSEMBLY DETAIL



SECTION D-D
SCALE 3:10

SECTION E-E
SCALE 3:10

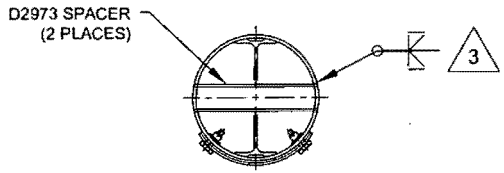


D3582-041 BLACK ANTI-SKID DETAIL

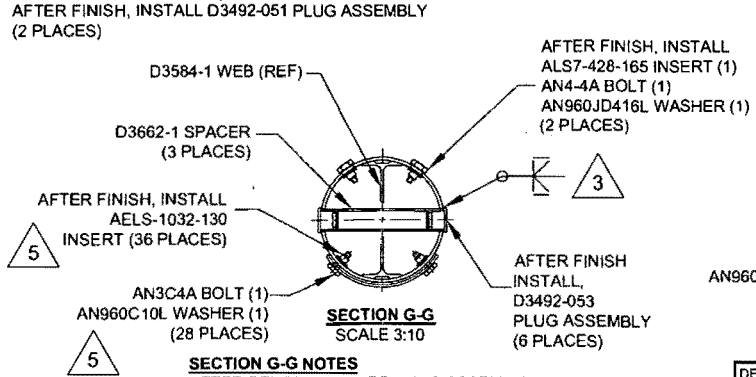
DEO ATTACHED

SECTION D-D NOTES
AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING:
1. CHAMFER HOLE 0.030 x 45°
2. INSERT D2971 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. PASS Ø0.750 DRILL TO REMOVE SPILL OVER
5. AFTER FINISH, INSTALL D3492-049 PLUG ASSEMBLY (2 PLACES)

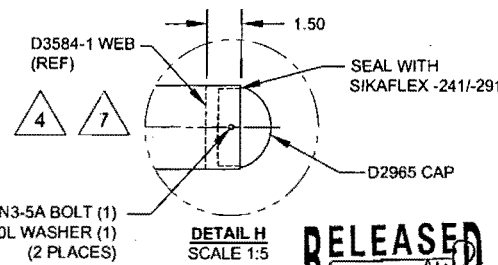
SECTION E-E NOTES
AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING:
1. CHAMFER HOLE 0.030 x 45°
2. INSERT D3662-3 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. PASS Ø0.672 DRILL TO REMOVE SPILL OVER
5. AFTER FINISH, INSTALL D3492-051 PLUG ASSEMBLY (2 PLACES)



SECTION F-F
SCALE 3:10



SECTION G-G
SCALE 3:10



DETAIL H
SCALE 1:5

RELEASED
07.11.22

SECTION F-F NOTES
AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING:
1. CHAMFER HOLE 0.030 x 45°
2. INSERT D2973 SPACER (2 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. PASS Ø0.625 DRILL TO REMOVE SPILL OVER

SECTION G-G NOTES
AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING:
1. CHAMFER HOLE 0.030 x 45°
2. INSERT D3662-1 SPACER (3 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. PASS Ø0.515 DRILL TO REMOVE SPILL OVER
5. AFTER FINISH, INSTALL D3492-053 PLUG ASSEMBLY (6 PLACES)

DESIGN	AH	**DART AEROSPACE USA, INC** PORT HADLOCK, WA
DRAWN	AH	
CHECKED		DRAWING NO. D3582 — REV. A — SHEET 2 OF 2
MFG. APPR.		TITLE: BK 117 SKIDTUBE ASSEMBLY — SCALE: 1:20
APPROVED		
DE APPR.		
DATE	07.06.08	

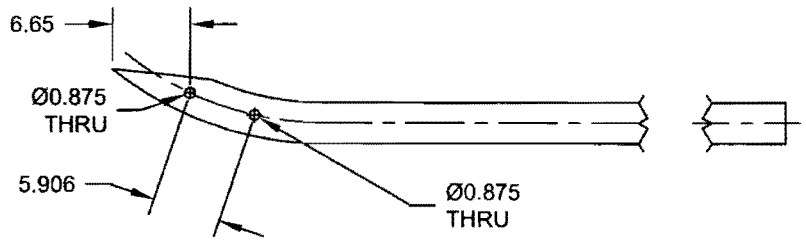
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DRAWING NO.	TITLE	REV. A	DART AEROSPACE USA, INC	D.E.O. NO.	SHEET NO.	SCALE
D3582	BK 117 SKIDTUBE ASSEMBLY		ENGINEERING ORDER	D3582-A-1	SHEET 1 OF 1	NTS

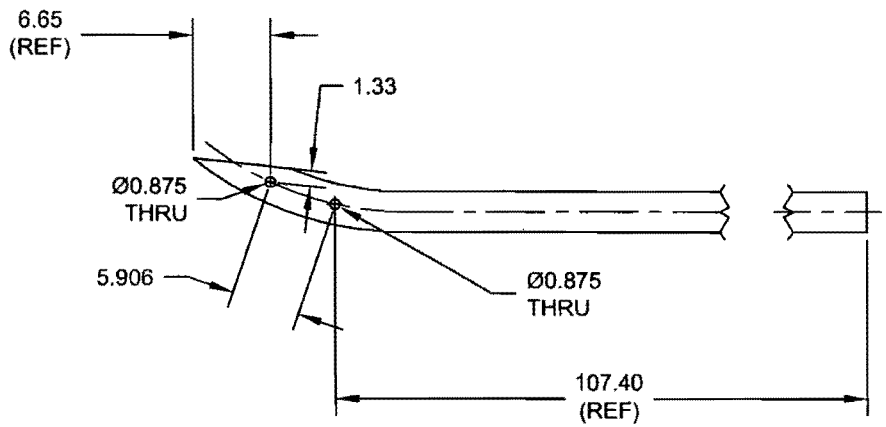
DRAWN	CHECKED	MFG. APPR.	APPROVED	DE APPR.
PH				
DATE 09.04.06	DATE 09.04.06	DATE 09.04.06	DATE 09/04/06	DATE 09.04.06

FOR EASE OF MANUFACTURE AND TO ENSURE THE FIT OF BRISTOL WIRESTRIKE SKID GEAR DEFLECTOR:
UPDATE DIMENSIONING OF 2 FWD HOLES ON SHEET 1 AS SHOWN

IS:



WAS:



RELEASED
09/04/22

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NO. 245

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barklay Elliott
Job number: 65186
Part number: 5117-762-041
Description: 17 Skid tube
Welding Process: Tig[✓] Mig[]
Base materiel: Aluminum
Current: AC[X] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:	pass[✓] fail[]
Penetration:	pass[✓] fail[]

UNACCEPTABLE

Cracks:	pass[✓] fail[]
Undercut:	pass[✓] fail[]
Pin holes:	pass[✓] fail[]
Overlap (cold lap)	pass[✓] fail[]
Porosity (surface):	pass[✓] fail[]
Coloration:	pass[✓] fail[]

Qualifier Nat Simms **Date of Test Coupon** 11-01-31

Welder Barklay Elliott **Date of Test Coupon** 11-01-31

The above named individual is qualified in accordance with AWS D17.1.2001 to weld